

Work Order ID 143913-2

143913

Page 1

March 28, 2016 2:58:32 PM

Item ID: D212-725-1-231

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Stiffener Angle

Start Date: 4/8/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 4/14/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: SH Date: 20160329 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4262	A								
100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1-Cut as per dwg 2-Make radius as pre dwg and deburr								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Chemical Conversion Coat per QS1005 4.1	0.00							
120									
HandFinish	Memo	0.00							
Hand Finishing									

Handwritten: Cancel split in 6.5.06

Work Order ID 143913

March 28, 2016 2:58:32 PM

143913

Page 2

Item ID: D212-725-1-231 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Stiffener Angle
Start Date: 4/8/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 4/14/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: _____	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

u 16.03.06

Picklist Print

Page 1

March 28, 2016 2:58:31 PM

Work Order ID: 143913

143913

Parent Item: D212-725-1-231

D212-725-1-231

Parent Item Name: Stiffener Angle

Start Date: 4/8/2016

Required Date: 4/14/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.10.28 as per dwg revF DD verfec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3A1.0X1.5X12 5		Purchased	No			100	f	9.9540	1.542	16.23158			

M2024T3A1 0X1 5X125

Angle 2024T3511 1.0x1.50x .125w

FF

APR 06 2016

Location

Loc Qty

Loc Code

GA002

9.954

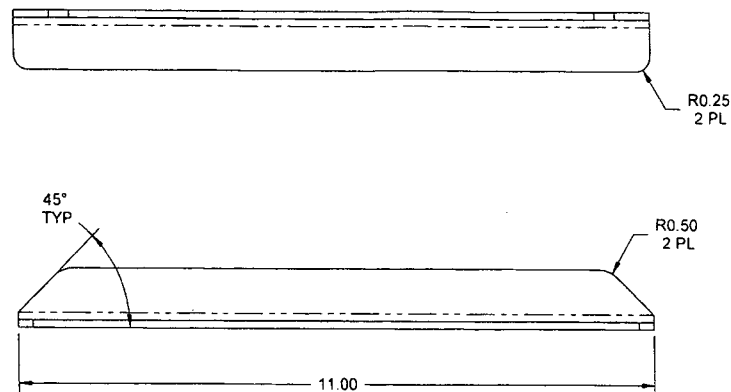
121697

1.104

M130691

8.85

~~16.23158~~ 6.492632



D212-725-1-233 STIFFENER ANGLE

RELEASED
2011-08-25
ND

NOTES:

- 1) MATERIAL: 2024-T3/T3510/T3511 ALUMINUM ANGLE
PER QQ-A-200/3
OR AMS 4152, 4164 & 4165
PER DART SPEC. M2024T3A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.26 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4262	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STIFFENER ANGLE	NTS
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